

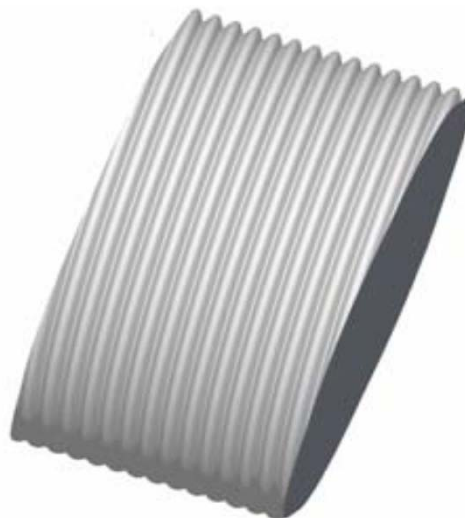
Cylindrical Thread Rolling Die

A21-010





HSS Cylindrical Thread Rolling
Die production with CBN
wheels.

Wheel No. 1 CBN three profile
wheel.

Wheel No. 2 CBN single profile
wheel



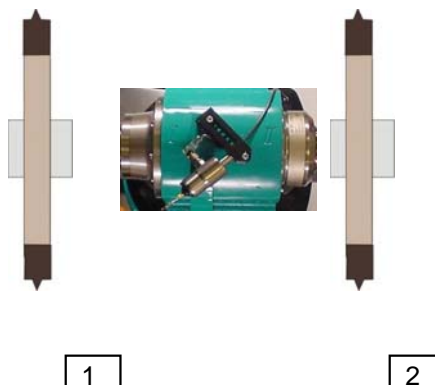
1. Cycletime for Production

Workpiece: Ø178 L76 Z310 P1.805 Helix 21° Material HSS		
Operations	 MainThread	 MainThread
Feed [mm/Min]	250	450
Increments [tot./part.]	0.2/0.02	0.01/0.01
Cutting speed [m/s]	38	40
Used wheels	 1	 2
Grinding time [s]	1941	3099
Total cycle time	84 Min	

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	DXF Ø200 B106
2	DXF Ø200 B46



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMAcfg

Control: Fanuc 31i

Accessories:

Responsible engineer: OP, 25.5.13

Coolant: Synthetic Oil, pressure 10 bar

Software: Quinto 5

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